

Date: Sunday, 10/05/2009 7:59:16 AM
 User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE FITTING
Job Number	: 47827		
Estimate Number	: 13925		
P.O. Number	:	Part Number	: D38832
This Issue	: 10/05/2009 S.O. No. :	Drawing Number	: D3883 PREL
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : MACHINED PARTS	Drawing Revision	: PREL
Previous Run	:	Material	:
Written By	:	Due Date	: 17/05/2009
Checked & Approved By	: <u>MF09-05-10</u>	Qty:	<u>4</u> Um: Each
Comment	: Est Rev:A New Issue 09-05-09 JLM Verified By:EC		



Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	D6101015	Saddle Billet
Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s) 7075-T7351 9.450 X6.250 Make from D6101-015 billet for D3883-1/2 Ensure that grain is along 9.450 " length Batch No: <u>B47459</u>		
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No. <u>B47827</u> Double check by: <u>DJP</u> 1-Machine Step No 1 per Folio FA817 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA817 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA817 and inspect per attached Dimension Sheets 4-Deburr <u>SL</u> 09/08/29		
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D3883 <u>mf</u> 09/05/29 (2)		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>SL</u> 09/05/29		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Sunday, 10/05/2009 7:59:17 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING

Job Number: 47827

Part Number: D38832

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK

**ENGINEERING
APPROVAL**



Comment: SECOND CHECK

09.06.08 *09/06/05*

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FL 09/06/09 *(2)*

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

1111472

START TIME:

2:00pm

OVEN TEMPERATURE:

320°F

FINISH TIME:

2:30pm

09-06-09

(X2)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

give to Jason M.

BR 09-06-09

(2)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Assy on D119-646-213/112

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



POSITIVE RECALL

EFFECTIVE *09.05.11* AUTH *[Signature]*

RELEASED _____ DATE _____

ENG USE ONLY *09.09.02*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order:	47827
Description:				Part Number:	D3883-2
Inspection Dwg:	Rev:	DSK:	Rev:	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
A	0.886	.906		.896	.896			
B	2.870	2.880		2.875	2.875			
C	1.433	1.453		1.438	1.438			
D	3.895	3.905		3.900	3.900			
E	0.791	0.811		.810	.810			
F	0.115	0.135		.135	.135			
G	Ø 0.257	Ø 0.262		.259	.259			
H	1.120	1.130		1.125	1.125			
I	2.245	2.255		2.250	2.250			
J	0.843	0.863		.852	.852			
K	0.240	0.260		.260	.258			
L	0.140	0.165		.155	.155			
M	2.000	2.020		2.001	2.000			
N	0.040 X 45°	0.060 X 45°		.046 X 45°	.046 X 45°			
O	5.990	6.010		5.997	6.000			
P	0.490	0.510		.501	.500			
Q	1.220	1.280		1.270	1.270			
R	R 0.620	R 0.680						
S	R 0.280	R 0.340						
T	0.115	0.135		.125	.125			
U	Ø 0.313	Ø 0.318		.316	.316			
V	0.020 X 45°	0.040 X 45°		.030 X 45°	.030 X 45°			
W	1.245	1.255		1.250	1.250			
X	2.495	2.505		2.500	2.500			
Y	0.490	0.510		.504	.505			
Z	1.245	1.255		1.250	1.250			
AA	7°	8°		7°	7°			
AB	0.140	0.165		.157	.156			
AC	1.265	1.285		1.267	1.265			
AD	R 0.470	R 0.530		.500	.500			
AE	R 0.178	R 0.198		.188	.188			
AF	0.240	0.260		.249	.249			
AG	0.110	0.140		.140	.140			
AH	0.240	0.260		.251	.251			
Accept/Reject								

Measured by:	<i>JL</i>	Date:		
Audited by:	<i>SP</i>	Date:	09/08/05	
Prototype Approval:	<i>JP</i>	Date:	05.06.05	
Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.11.08	Reformat	KJ/JLM	

DART AEROSPACE LTD				Work Order:	47827
Description:				Part Number:	D3883-2
Inspection Dwg:	Rev:	DSK:	Rev:	Page 2 of 2	

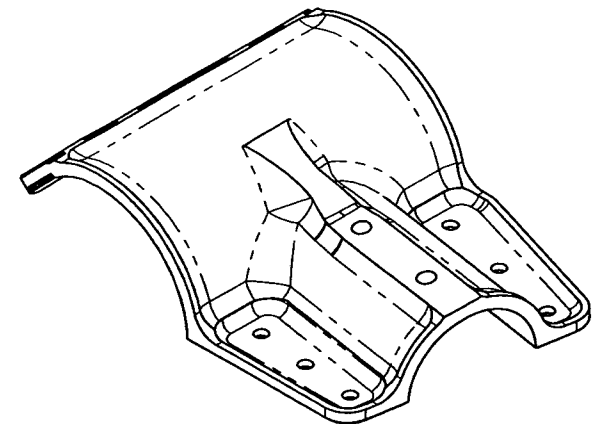
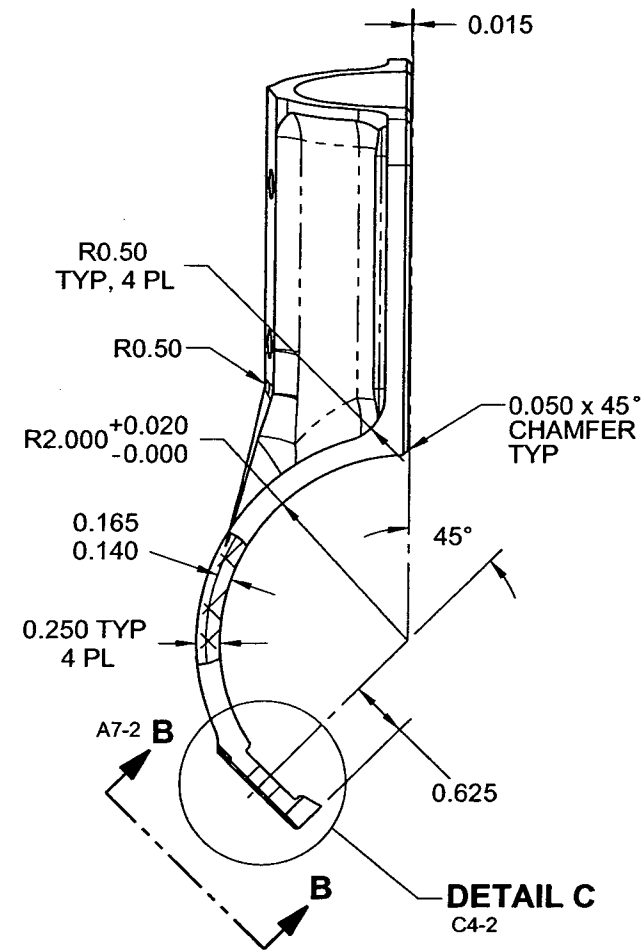
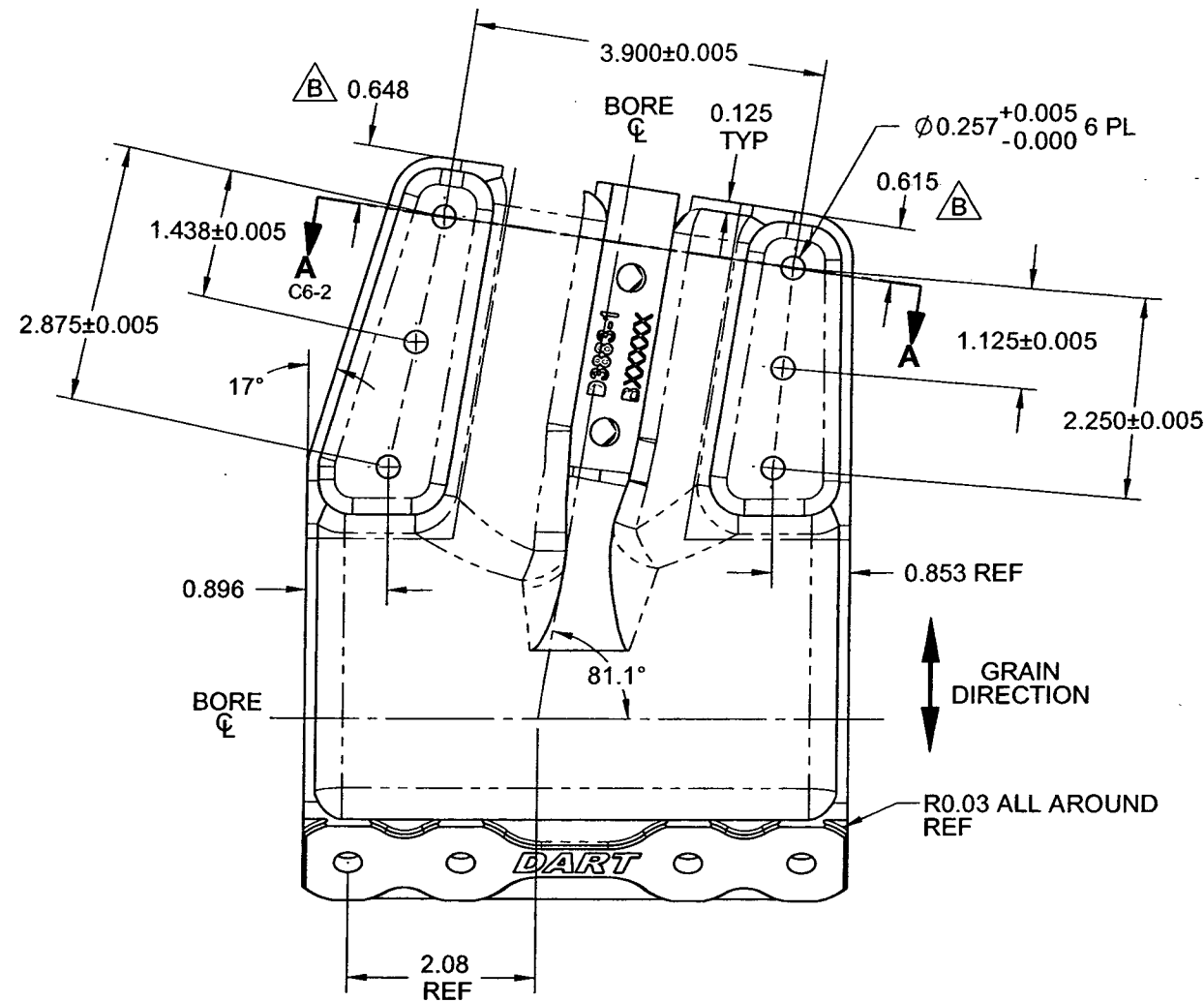
FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
A	0.740	0.960		.760	.760			
B	2.825	2.885		2.868	2.868			
C	1.211	1.231						
D	R0.470	R0.530		.500	.500			
E	R0.015	R0.035						
F	R0.015 X 45°	R0.035 X 45°		.025 X 45°	.025 X 45°			
G	0.235	0.255		.246	.247			
H	0.760	0.765		.760	.760			
I	0.215	0.220		.220	.220			
J	0.050	0.070		.060	.060			
K	0.260	0.280						
L	0.615	0.635		.625	.626			
M	R0.470	R0.530		.500	.500			
N	R0.470	R0.530		.500	.500			
O	Ø0.316	Ø0.321		.320	.320			
P	0.990	1.010		1.009	1.005			
Q	1.750	1.755		1.750	1.750			
R								
S								
T								
U								
V								
W								
X								
Y								
Z								
AA								
AB								
AC								
AD								
AE								
AF								
AG								
AH								
Accept/Reject								

Measured by:	<i>[Signature]</i>	Date:	
Audited by:	<i>[Signature]</i>	Date:	09/06/05
Prototype Approval:	<i>[Signature]</i>	Date:	09.06.03

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.11.08	Reformat	KJ/JLM	



**PRELIMINARY
ISSUE** *P 09.06.05*

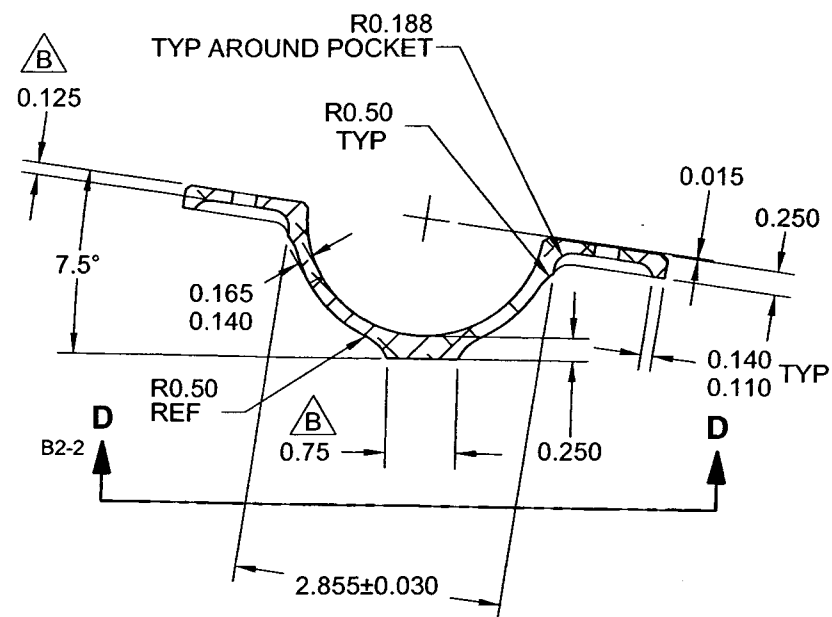
PRELIMINARY

**D3883-1 SADDLE, OUTBOARD LH (SHOWN)
D3883-2 SADDLE, OUTBOARD RH (OPPOSITE)**

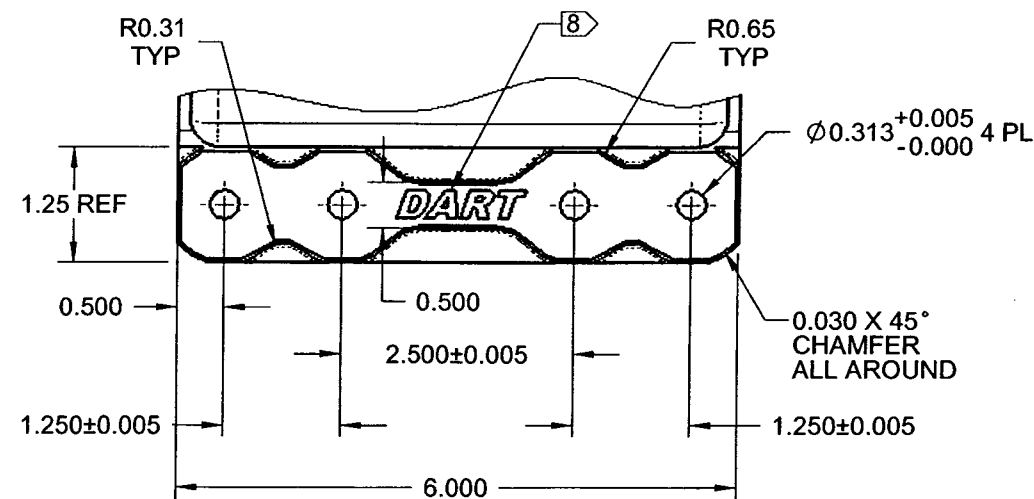
NOTES:

- 1) MATERIAL: 7075-T7351 ALUMINUM PER AMS-QQ-A-250/12, OR QQ-A-250/12 OR ASTM B209 (REF DART SPEC. D6101-015)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO
MAX. DEPTH OF 0.010 WITH A MIN. TOOL RAD OF R0.010
- 7) WEIGHT: 1.00 lbs
- 8) ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.250

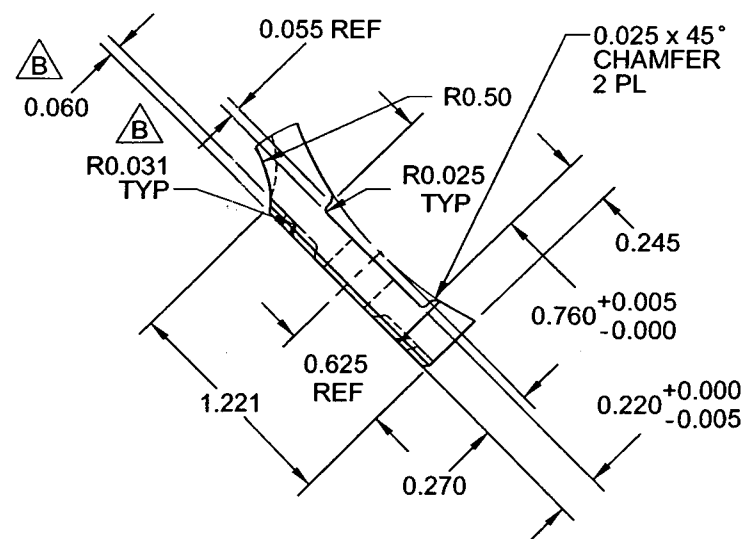
B	D6101-015 WAS D6102-015. ZN A7-1; ADD 0.648. ZN D7-1; ADD 0.615. ZN D6-1; ADD 0.125. ZN D7-2; ADD 0.060 & R0.31. ZN B5-2; ADD 0.060. ZN B5-2; 0.75 WAS 0.728. ZN C7-2	RF	09.06.05
A	NEW ISSUE	RF	09.04.23
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3883	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		OUTBOARD SADDLE	NTS
DATE	09.06.05	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



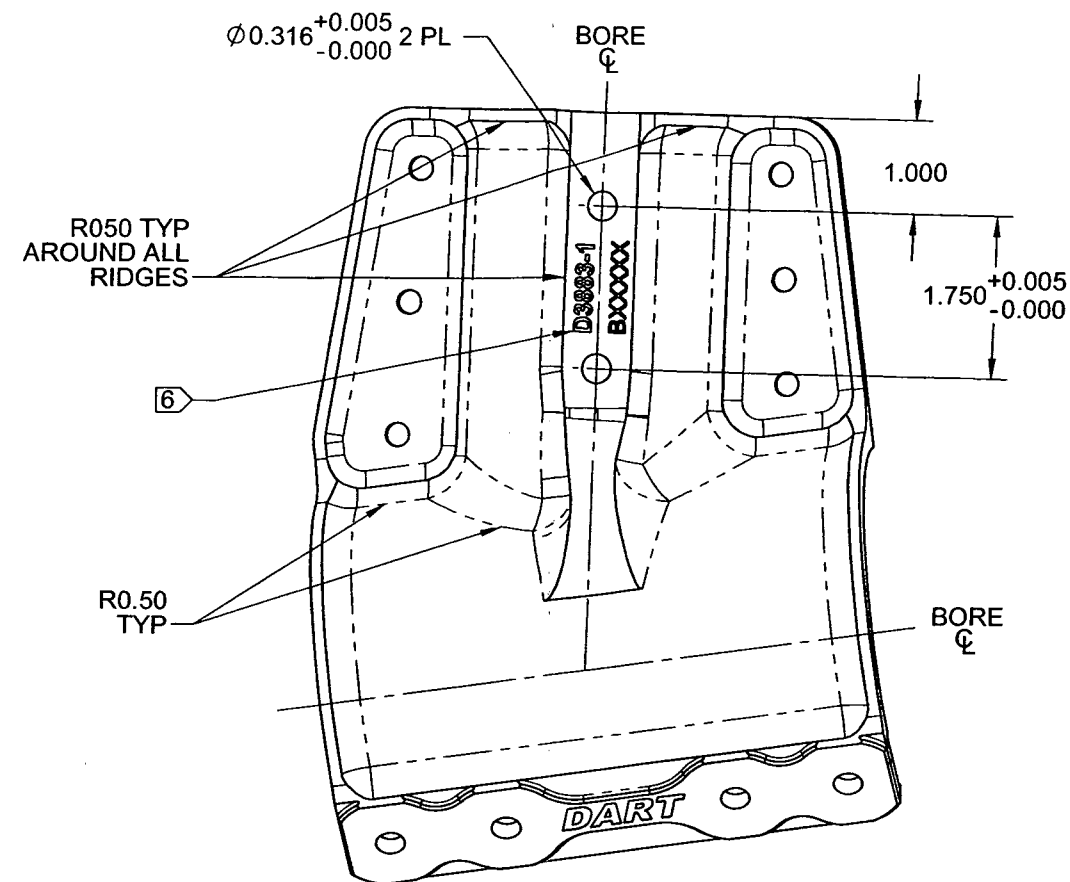
SECTION A-A C7-1



VIEW B-B B4-1
(ROTATED FOR CLARITY)



DETAIL C B3-1
SCALE 2X

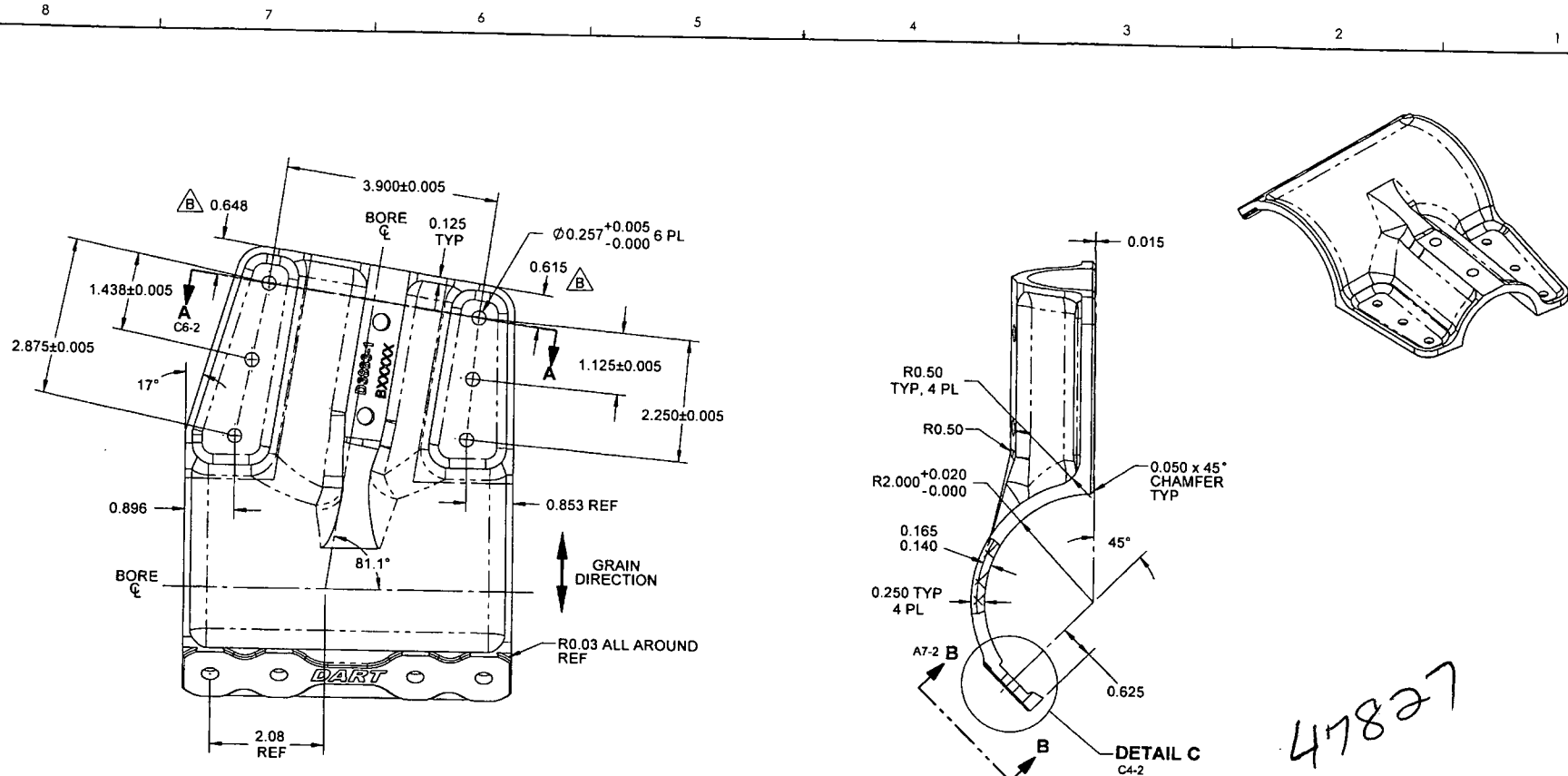


VIEW D-D C7-2

**PRELIMINARY
ISSUE**

PRELIMINARY

DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED		DRAWING NO. D3883	REV. B
MFG. APPR.			SHEET 2 OF 2
APPROVED		TITLE OUTBOARD SADDLE	SCALE NTS
DE APPR.			
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D3883-1 SADDLE, OUTBOARD LH (SHOWN)
D3883-2 SADDLE, OUTBOARD RH (OPPOSITE)

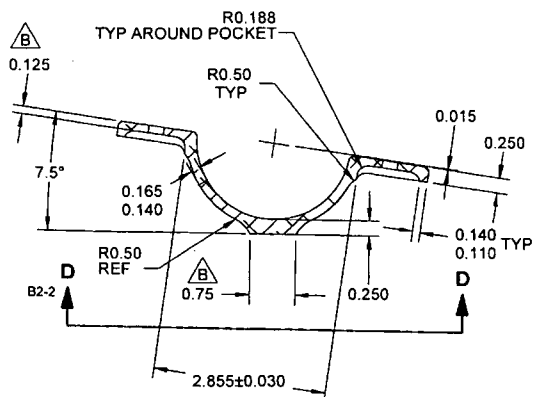
47827

RELEASED
01/07/15

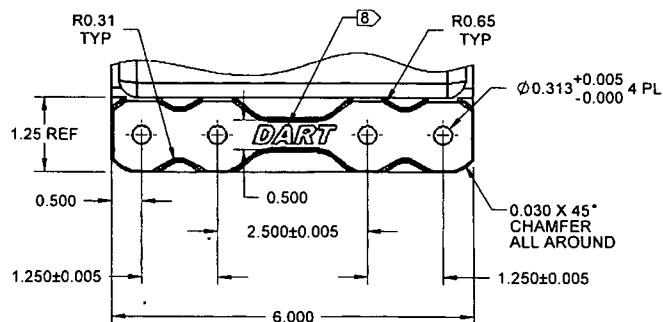
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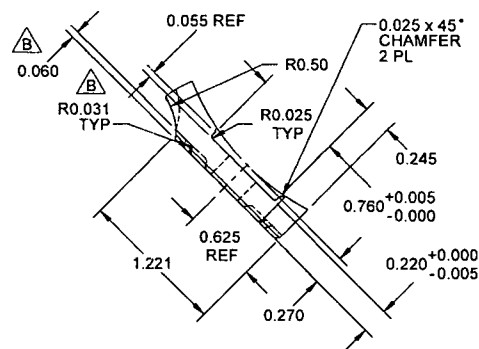
B	D6101-015 WAS D6102-015, ZN A7-1; ADD 0.648, ZN D7-1; ADD 0.615, ZN D6-1; ADD 0.125, ZN D7-2; ADD 0.060 & R0.031, ZN B5-2, 0.75 WAS 0.728, ZN C7-2	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3883	SHEET 1 OF 2
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	OUTBOARD SADDLE	NTS
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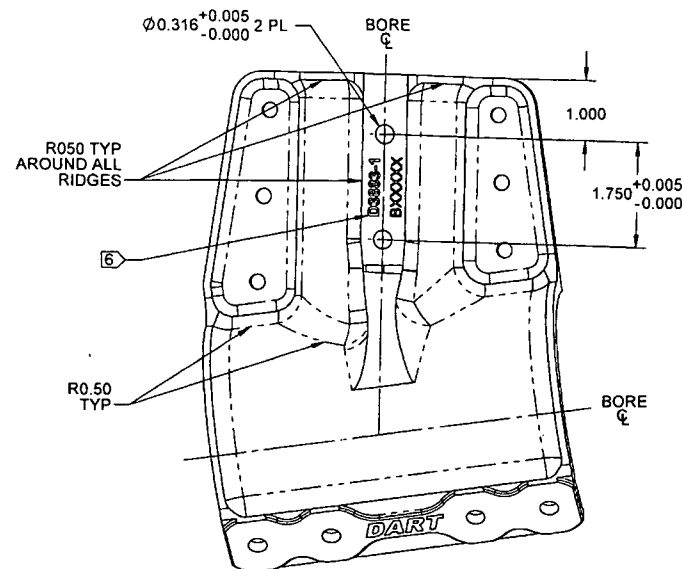
SECTION A-A C7-1



VIEW B-B B4-1
(ROTATED FOR CLARITY)



DETAIL C B3-1
SCALE 2X



VIEW D-D C7-2

47827
RELEASED
09/07/15

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.		D3883	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		OUTBOARD SADDLE	NTS
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